

Date: Thursday, 3/2/2006 3:07:49 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HINGE BRACKET
 Job Number : 26034
 Estimate Number : 10347
 P.O. Number : N/A Part Number : D28572
 This Issue : 3/2/2006 S.O. No. : N/A Drawing Number : D2857 REV A1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A1
 Previous Run : 24626 Material : N/A
 Due Date : 3/26/2006 Qty: 25 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : JL 06.03.02
 Comment : Est C 00.06.22 Removed P/O for powder coat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2000X01250 6061-T6 Bar 2.0" x 1.25"



Comment: Qty.: 0.4594 f(s)/Unit Total : 11.0250 f(s)
 Material: 2.00" X 1.25"
 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)
 (M6061T6B200001250)
 Batch M100451

SA 06.03.27 25

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks 5.2"

SA 06.03.27 25

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2857-1
D2857-2

J-L/SA 06.03.30 25

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J-L/SA 06.03.30 25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *LD* Date: 06/04/06

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 3:07:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 26034

Part Number: D28572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

SD 06.03.30

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

DL 06/04/01

(25)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 06.04.01

25

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

DL 06/04/02

(25)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PD 06/4/5

(25)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 165

PD 06/4/5

(25)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PD 06/04/06

(25)

Job Completion



U 060405

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26034
Description: Hinge Bracket		Part Number:	D2857-2
Inspection Dwg: D2857 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.301	✓			
0.340	+/-0.010	0.340	✓			
1.110	+/-0.005	1.110	✓			
1.790	+/-0.010	1.790	✓			
1.320	+/-0.005	1.320	✓			
2.000	+/-0.010	2.000	✓			
Ø0.171	+0.005/-0.000	0.174	✓			
0.147	+/-0.010	0.145	✓			
0.376	+/-0.010	0.375	✓			
0.126	+/-0.010	0.128	✓			
0.611	+/-0.010	0.612	✓			
0.063	+/-0.010	0.067	✓			
Ø0.166	+0.005/-0.000	0.168	✓			
0.911	+/-0.010	0.912	✓			
0.600	+/-0.010	0.609	✓			
0.125	+/-0.010	0.129	✓			
0.150	+/-0.010	0.150	✓			

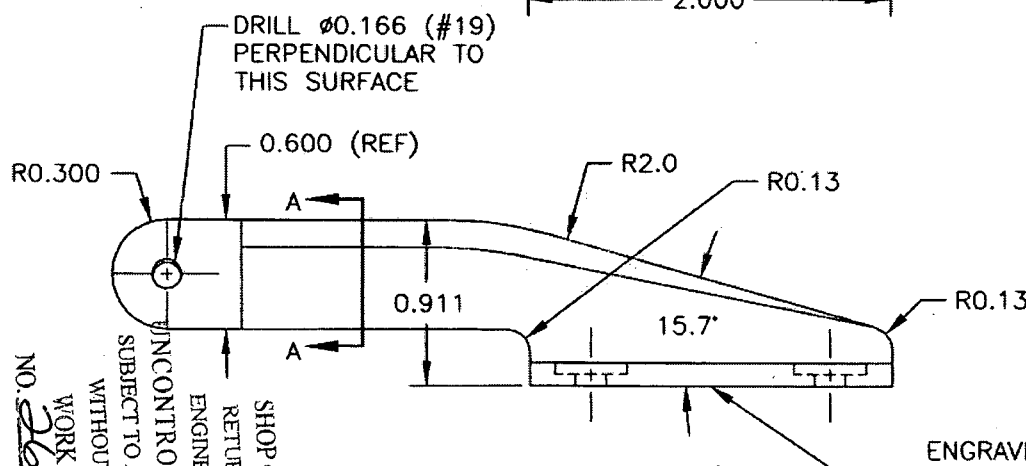
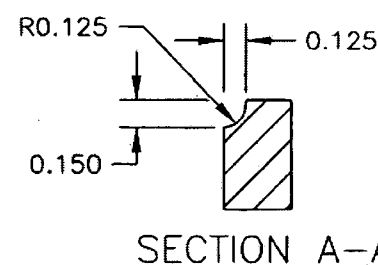
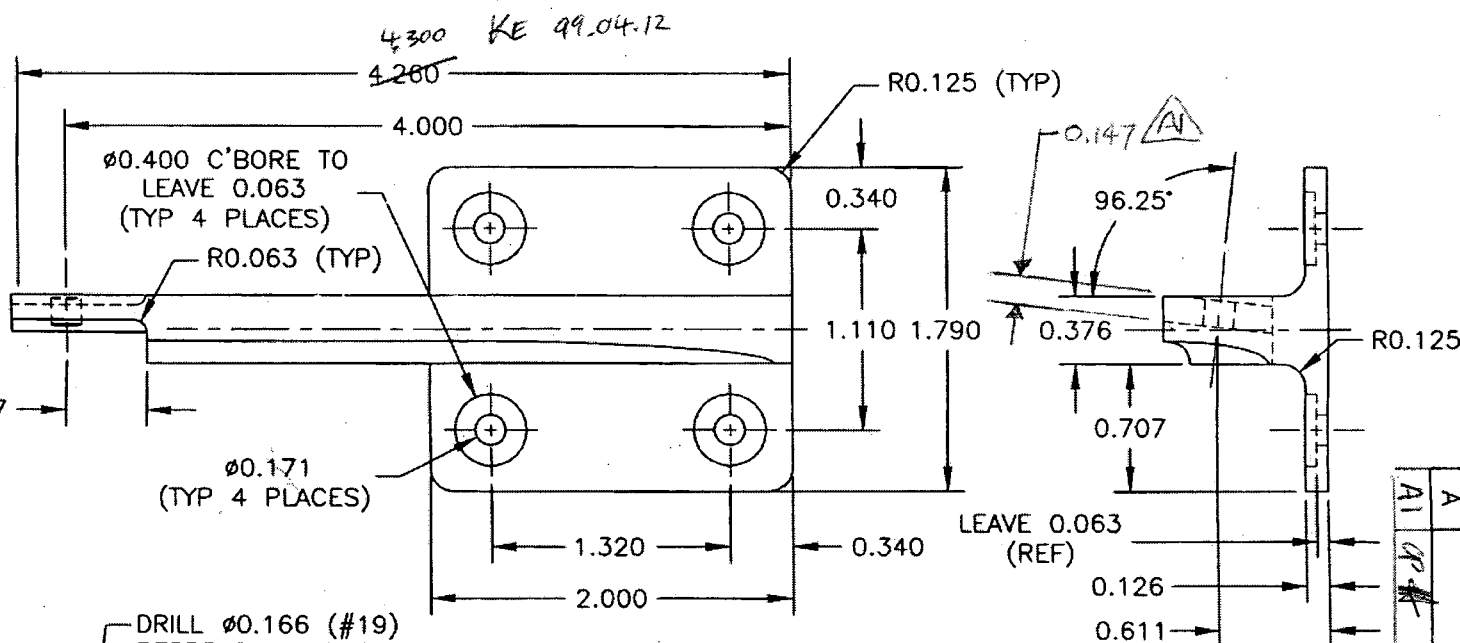
Measured by:	JL	Audited by:	En	Prototype Approval:	N/A
Date:	06.03.29	Date:	06/03/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSBURG, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>SP</i>	DRAWING NO. D2857
DATE 98.12.14	TITLE HINGE BRACKET	REV. A SHEET 1 OF 1
A	98.12.14	NEW ISSUE
A1	02.04.29	ADD THICKNESS

RELEASED
qq.01.06 KE



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2857-1 SHOWN
D2857-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 26034
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY